

TEAGUE ENTERPRISES

DESIGN - TESTING - MANUFACTURING

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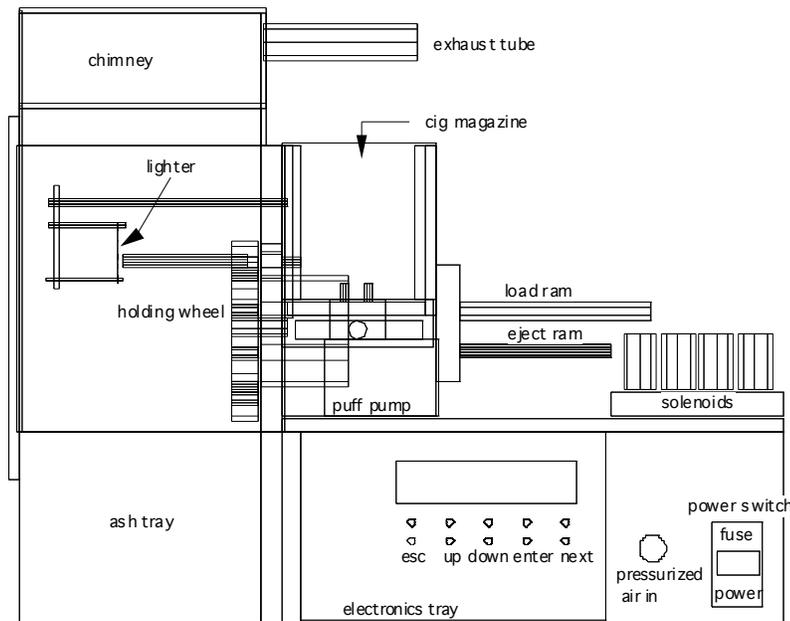
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TE-10 Operating Instructions Sep 2008



General Description: Smoking Machine



Smoke machine

The TE-10 is a microprocessor controlled cigarette smoking machine that produces either side-stream or main-stream smoke (or a combination of the two) from research cigarettes. Regular commercial cigarettes with a diameter of 0.311" (7.9 mm) and length less than 3.2" (81.3 mm) can also be used. Cigarettes are automatically loaded into a wheel, lit, puffed and ejected. One to ten cigarettes can be smoked at a time using the FTC method of puffing for 2 seconds, once a minute at a volume of 35 cm³. Up to 40 cigarettes can be placed into the machine for loading at one time and cigarettes are smoked for 9 minutes each. Ejected cigarettes are extinguished in a water tray. The number of cigarettes, in the one cigarette configuration, needed for one hour of operation is 6.6. Burning three cigarettes at a time would use 20 cigarettes an hour and so on.

Smoking systems generally have a smoking machine, some method to mix and dilute the smoke and an exposure unit. In conjunction with a mixing and aging chamber, a range of concentrations with side-stream, main stream or mixed smoke can be produced. The machine's applications include use with animal and cell culture exposure systems, serial animal exposure chambers and nose-only chambers. To maintain a target concentration a dynamic system is required where smoke is produced at a constant rate, mixed and diluted, and metered to the exposure cabinet at a constant rate and then exhausted. TSP levels from .01 milligram per cubic meter to 600 mg/m³ have been generated with TE systems. The whole body system consists of the TE-10 in a hood unit with the mixing chamber. Flow is metered to the exposure chambers and comes back to the fan under the hood and then exits to be exhausted. The number of cigarettes and the flow rate through the chambers determines smoke concentration.

Operation:

The TE-10 uses a custom designed microprocessor board to control the smoking machine operations. The cigarettes are loaded in the magazine by tilting the cigarettes and placing them one on top of the other, with the filter on the right side, until they reach the top. Air cylinders that perform the loading and ejecting tasks operate the moving parts. The solenoids are activated by 12 vdc from the microprocessor and operated with compressed air. The air control solenoids are three-way valves normally open to the air cylinder side. The sequence starts by moving cigarettes from the magazine into the chamber for placement of the cigarette into the wheel. With the solenoid in the "on" position, air is opened to the spring return air cylinder. The piston is connected to the sliding receiver at the bottom of the stack of cigarettes in the magazine. The program starts when the power is turned on and the number of cigarettes to be placed in the wheel is determined. The motor is activated and searches for the zero position by rotating the wheel until a magnet in the wheel activates a switch. The stepper motor then moves the wheel to the eject position and activates the eject ram and the magazine load ram to place a cigarette into the load chamber. The program then moves to the load position and activates the load ram air cylinder by pushing the cigarette into the wheel. As the cigarette moves counterclockwise to the one o'clock position the lighter turns on. The lighter duty cycle number adjusts the power to the lighter wire. This is set at the start of the smoking and should not have to be reset. At the 12 o'clock position, the cigarette contacts with the lighter and starts burning. A two second puff is then taken on the new cigarette. The puff signal turns on the puff pump, which is calibrated to flow at 1.05 LPM, and results in a puff of 35 cubic centimeters. The machine continues to load cigarettes, light and puff them corresponding to the number chosen in the start program. Cigarettes move around so each is puffed once a minute for two seconds. Each cigarette is puffed nine times and is then ejected by the eject ram where it falls into the ashtray and is extinguished by the water. The cigarette is then replaced by a new cigarette from the magazine and starts the same cycle of lighting and puffing as the first set.

Research Cigarettes:

Most of the smoking systems being used in the US are using standard reference cigarettes. There are a number of these cigarette types and are sold by the University of Kentucky, Lexington, KY. The most widely used is the 3R4F cigarette (low tar modern cigarette). More information on the composition and analysis of the reference cigarettes and purchasing of the cigarettes can be obtained by contacting them. As part of the FTC method the cigarettes are stored at 4°C until needed. At least 48 h prior to use, the cigarettes are placed in a closed chamber at 23°C along with a solution of glycerin/water (mixed in a ratio of 0.76/0.26) to establish a relative humidity (RH) of 60%.

TE-10 description:

The machine is composed of four sections: **cabinet, cigarette handling, chimney and ash collection tray.**

The **cabinet** houses the power supply, air pressure gauge, solenoid block, and electronics tray (control microprocessor).

- **Power supply** –110 to 240 VAC power unit delivers 12 VDC regulated power for the microprocessor, solenoids, lighter and stepper motor. Fuse (4 Amp) is above the switch on front of machine.



- **Air pressure gauge** -- 0 to 60 psi from air connection on front of cabinet indicates air pressure to solenoids for air pistons. A user-provided air regulator is needed to provide pressure at 25 PSI (monitored by a pressure gauge) to operate the air cylinders. “Presto-loc” fittings are used throughout the system and the tubing must be pushed in securely to insure proper sealing on the tubes.

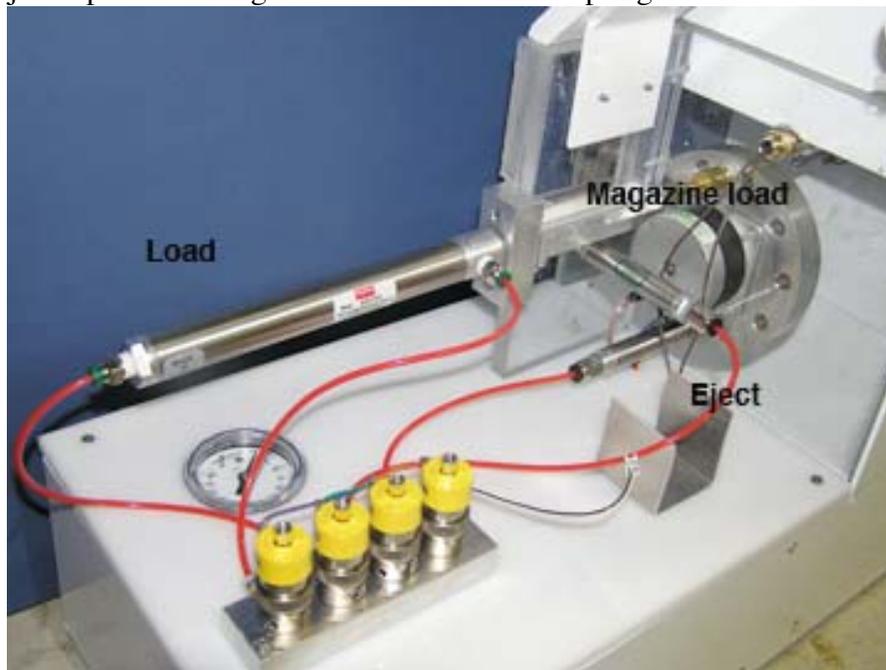


- **Solenoids** – The four solenoids direct the compressed air to activate the three air pistons. When off top connector is open to the room.

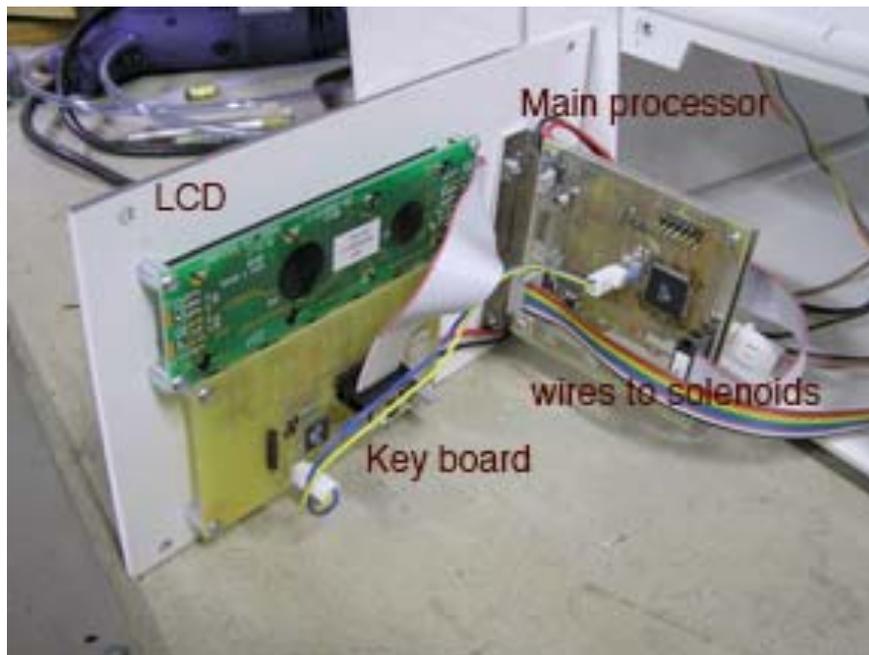


- **Air pistons**

1. Magazine load – moves cigarettes into loading chamber. Spring return.
2. Load – (ram cylinder) pushes the cigarette into the wheel. Uses two solenoids one to activate the rod and the other to retract it.
3. Eject – pushes the cigarette out of the wheel. Spring return.



- **Electronics tray** – front part of the tray holds the PCB (printed circuit board) and contains the controls and indicators for the operation of the microprocessor. An LCD (liquid crystal display) 16 character two lines displays the information for operation.



Start Up Procedure:

1. Make sure the loading mechanism is free of debris, puff pump has been cleaned and everything is connected and in place.
2. Place fresh water in the extinguishing ash drawer to a level about half to three quarters full.
3. Plug in the pressure line and adjust line pressure to 25 – 30 PSI on smoking machine gauge.
4. Load magazine with research cigarettes in the proper orientation (filter to rear).
5. Plug in machine and push the power rocker switch.
6. After the machine is turned on and wheel stops the program may be changed to desired settings. The wheel has a magnet in the backside that activates a reed switch to set the zero position. The “next” button must be depressed immediately after wheel stops to activate this option. If the switch is not depressed soon enough the machine will start operating on the loaded program. The “next” button cycles through the options. The options are:
 1. Number of cigarettes: toggle up and down switches to number desired. Push “enter” switch and then “esc” when done.
 2. Wheel offset alignment. Used to set the hole to proper location. This is preset at factory.



3. Lighter power duty cycle: toggle up for more current and down for less. The best point is where the wire just starts to glow red. Push “enter” switch and then “esc” when done.
4. On time. The *on time* may be set for any time from 1 to 999 minutes. The time is set by using the up and down switches.
5. Off time. The *off time* has the same range and is set the same way as *on time*. If the *off time* is set to zero the *on time* is never activated. After the indicated *off time* is timed out the machine starts up again. For example if the *on time* is set to three minutes and the *off time* is set for 2 minutes. The machine will load the cigarettes and light them puffing only three times and then eject all the cigarettes. After two minutes the machine will load the cigarettes again and go through three puffs before ejecting them
6. While the machine is running several operations can be used to help keep the cigarettes burning.

- a. Lighter on. The button above the esc button and below the soft key on the LCD indicating “L” will turn on the power to the lighting wire. Push on and hold to turn power on release to turn off.
- b. Puff on. The button above the UP button and below the soft key for puff “POFF” by holding this key the puff pump will be turned on. This may also be used to clean the puff pump in the methanol cleaning method detailed in the maintenance section.
- c. Eject all. The 4th button on the top below “eject” will eject all the cigarettes and stop the machine. The machine waits for the current cycle to finish before initiating the command.
- d. Pause. The 5th button on the top below the “pause” will stop the machine and stop immediately the operation at wherever it is. To restart the machine just push the button again. A timer records the time paused.

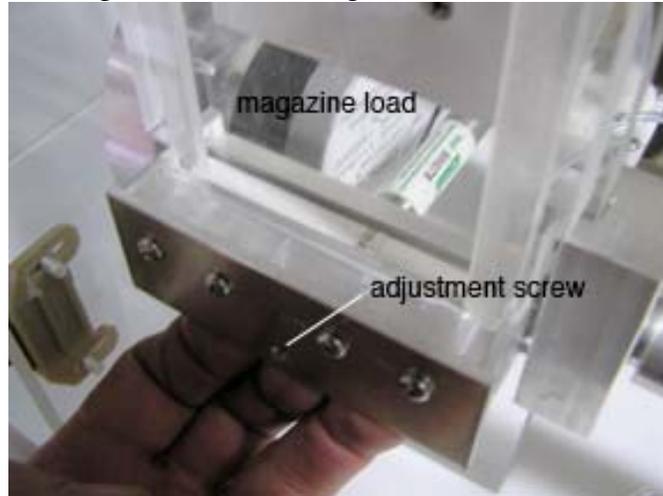
The **cigarette handling** parts include the cigarette-holding device (magazine), the cigarette-metering device (magazine load mechanism), the load piston, eject piston, the wheel that holds the cigarettes and the puffing pump.

- Magazine – holds the cigarettes stacked on each other. The lower part is part of the magazine load mechanism and is made of acrylic. The upper part is an extension attached to the acrylic section and is made of aluminum and canted at about 30 degrees. Up to 40 cigarettes can be loaded into the magazine and extension.

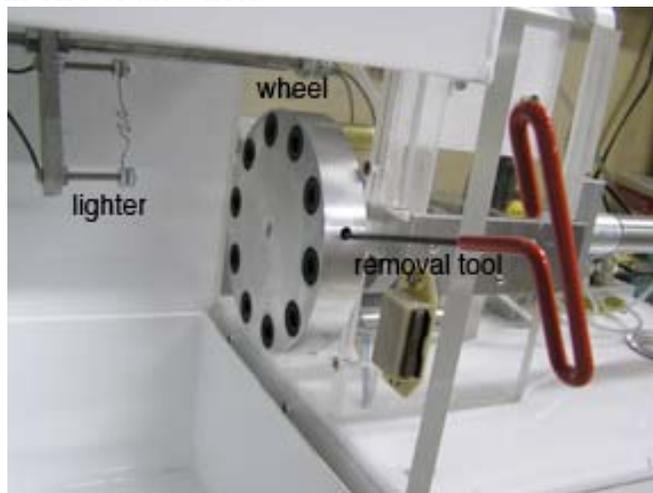


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- Magazine load – moves the cigarettes from the magazine to the loading chamber. A spring return air cylinder moves the sliding tray out to pick up a cigarette and returns to the rest position with the cigarette. This is the loading chamber.

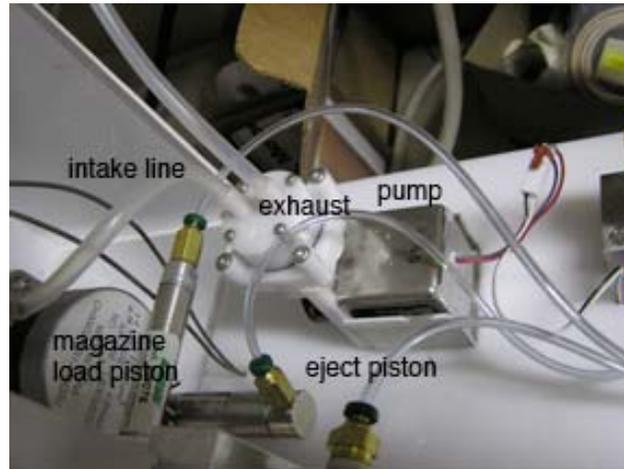


- Load – the load air piston pushes the cigarettes into the wheel. The cigarettes are pushed into the wheel from the loading chamber by an air piston with a 6 inch (15.24 cm) displacement. The rod is retracted by applying air to the air piston return port.
- Wheel – is an aluminum wheel 4.5 inches in diameter with ten holes tapered to hold the cigarettes. The wheel is held onto the shaft of the stepper motor by an Allen screw in the side of the wheel.



- The load piston pushes the cigarette through so that 3/8 of an inch (9.5 mm) of the cigarette is held in the wheel hole. A gasket in each hole made of 1/8 inch neoprene with an inner diameter of 0.30" (7.6 mm) holds the cigarette in a gas tight seal for puffing.

1. Eject – at this location (at 6 o'clock) a rod from a spring return air piston pushes the cigarette out of the wheel. Each cigarette is puffed nine times and then ejected by the piston to fall into the ash tray containing water where it is extinguished
 2. Load – at this position (about 2 o'clock) the cigarette is loaded into the wheel by the load piston.
 3. Puff—cigarettes are ignited by a nichrome wire and puffed once a minute at the top most or “puff” position. The puff hole contains a Teflon tube held against the wheel by a spring to provide adequate suction for puffing. The smoldering cigarette is puffed for 2 seconds at a flow rate of 1.05 LPM to provide a standard FTC puff of 35 cubic centimeters.
- Puffing pump—A 12 VDC pump is used to provide the negative pressure for the proper flow rate. In the mainstream plus side-stream configuration, mainstream smoke is added to the side-stream smoke at the exit of the collection hood.



The **chimney** area contains the wheel and lighting wire. This area encloses the burning cigarettes to capture the smoke from the smoldering cigarettes.

- Lighting wire – a nichrome wire 0.02 inches (0.51 mm) in diameter made of Ni 80/Cr 20 is suspended by two posts on a ceramic post made of 6-32 bolts. Wire is held in place by two opposing nuts. (New lighter wires can be purchased from Teague Enterprises)
- Chimney – made of aluminum on top with a tube out of one side for collecting the smoke. A door on the front allows access to the interior. Mainstream smoke is added to the side-stream smoke immediately after the collection tube leaves the chimney.

The **ash collection bin** is an aluminum box that is partially filled with water.

- Ashtray – aluminum drawer, which can hold a little over 4 liters of water. It is filled 1/2 to 3/4 full and extinguishes the cigarettes as they fall into the water when ejected.

Daily Maintenance:

1. Clean enclosure hood, wheel and magazine with spray soap solution. If debris is lodged behind the wheel, the wheel should be removed and the face and wheel should be cleaned.

2. Clean tar from puff port with cleaning swab dipped in methanol.
 - a. Remove the tubing from the brass fitting on the back of the puff port.
 - b. With the wet cotton swab push the swab (Q tip) through several times to remove tar.
 - c. Remove the floating Teflon washer and clean around spring area.



3. Vacuum tobacco chaff and other debris on unit and in loading mechanism.
3. Clean pump by running methanol through pump after each days use. If pump does not operate at required flow rate, disassembly and cleaning of pump head will have to be performed.
 - a. Disconnect the tubes from the fittings (puff port and exhaust tube) leaving on pump.
 - b. Place the exhaust tube into a small beaker. (Exhaust tube is closest to motor.)
 - c. Put about 25 ml of methanol into pump using a wash bottle or squirt bottle by just squirting some into the inlet port as the pump is turned on.

Weekly Maintenance:

1. Remove chimney and clean using methanol or some general purpose cleaner.
2. Clean out the chimney tube by running a rag soaked with methanol through it. Check the tube leading to the puff meter to make sure it is not obstructed by tar.
3. Remove the wheel and clean the ports and examine the gaskets for wear. Replace them if the gaskets will not hold the cigarettes tightly enough to form a gas tight seal. **Be very careful not to tighten setscrew with too much force, as this will distort wheel and shaft causing problems with centering the wheel as wheel hole is distorted.**

As Needed.

1. Replace hose from smoking machine to dilution chamber.

2. Remove door from dilution chamber and clean out with methanol and wipes. Also the fan must be cleaned and checked for operation. Do not turn on before the fan has dried out. The door is replaced and put back on after it is cleaned and allowed to dry out. If gasket is damaged or silicone was used originally replace the gasket with new material.
3. Remove line to the chambers by taking off the hose connecting to the dilution chamber. The pressure lines from the gauges on the front of the hood should be removed from the orifice meter. Examine the meter and hose and clean if necessary. If the hose is very dark it is easier to replace them than try to clean them.
4. Clean the valves going to the chambers by soaking in methanol and cleaning out.
5. Chambers should be cleaned and the distribution tubes cleaned out also. The tubes can be removed from the back of the chambers by removing the ductwork and pulling the tubes out.

Special Procedures:

Set Index offset number:

This may be needed if the electronics tray is replaced or a new wheel is put on.

1. When wheel stops immediately push the next switch. The wheel should remain stopped
2. Check the alignment by putting the cigarette pusher in the load hole (3 o'clock position facing wheel) or looking through side to see if the hole is aligned with the load hole.
3. Move wheel CW or CCW by pushing the up or down buttons. After one click of button check alignment by then pushing the enter key. Wheel should move one step. By moving the wheel forward or backward (CCW or CW) the hole should just align with the loading hole.
4. When wheel is aligned the esc (Escape) key is pressed and the machine will start operation. This number should be somewhere about 32 to 35.
5. No more adjustments should be necessary, as the machine will remember this number.

Unjamming cigarette:

1. Turn off machine.
2. Move the wheel so it is aligned with the holes on the faceplate.
3. Push cigarette from wheel side with pusher tool or rod into the loading chamber.
4. Move the cigarettes up with the holder and secure them so they are out of the way.
5. Pull the magazine load out and remove the smashed cigarette with a pair of pliers.
6. Vacuum out the debris with a vacuum cleaner by pulling out the magazine load mechanism several times while holding the vacuum nozzle in the tray.
7. Restart the machine.

Ignition wire replacement:

1. Use the replacement wire (nichrome -Ni 80%, Cr 20% .0120 inch), which is bent into the proper shape. The bent wire can be deformed into a convex shape (facing toward the cigarette). This form helps prevent the cigarette from catching on the end of the wire lighter and bending the lighter.
2. Remove the hood by taking out the four screws holding it on. This will facilitate access to the lighter post and make it much easier.
3. Remove the old lighter by screwing retaining screw out several turns and pulling off with pliers and holding on to the post with another pliers. Be careful not to break the ceramic post holder (it is brittle). The posts can also be removed from the holder and then pulled off the wire lighter.
4. Put a new nichrome wire around the post and tighten bolt on nut. Check nut on post connection to make it is secure on the wire from the lower unit.

Cleaning, checking and repair of puff pump:

Puffing pump—A 12 vdc pump is used to provide the negative pressure for the proper flow rate. In the mainstream plus side-stream configuration, the mainstream smoke is added to the side-stream smoke at the exit of the collection hood.

The pump is turned on for two seconds at the end of the cycle for each cigarette being smoked and cannot be changed. Because the smoking machine follows the FTC method when the flow rate is 1.1 LPM the puff will be 37 CCs.

Flow rate can be checked with the machine running by connecting a flow rate meter with a mass flow meter or a rotameter type such as “Visi-Float” flowmeter. The exhaust tube is disconnected from the chimney tube and connected to the bottom of the flowmeter. The picture shows flow around 2 LPM, which is about right because the cigarette will drop the pressure and flowrate to be close to the 1.1 LPM ideal flow.



Clean pump by running methanol through pump after each days use.

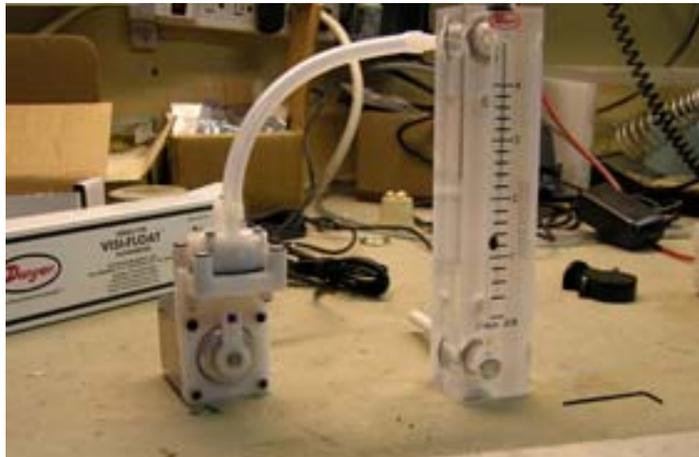
- d. Disconnect the tubes from the fittings (puff port and exhaust tube) leaving on pump.
- e. Place the exhaust tube into a small beaker. (Exhaust tube is closest to motor.)

- f. Put about 25 ml of methanol into pump using a wash bottle or squirt bottle by just squirting some into the inlet port as the pump is turned on. The discharge will be collected in the beaker.
- g. When the discharge is clear let it pump for about 15 seconds more.

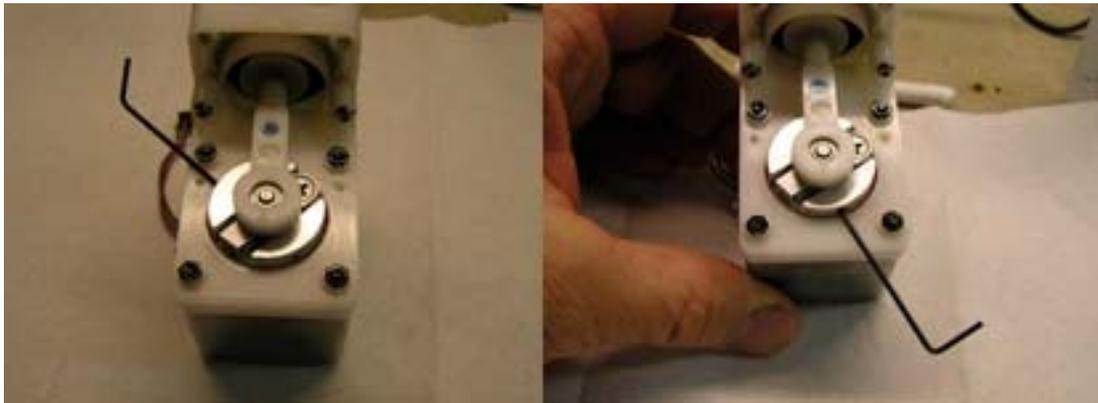


Cleaning and checking the flow rate using a 12 VDC power supply will allow one to keep a second pump ready to install and can be done while the smoking machine is operating.

- a. Cleaning is done the same way by squirting a small amount of methanol into the running pump and collecting it in a beaker.
- b. Calibrating or checking the pump is done by hooking the pump to a flow meter such as the 4 LPM Visi-Flow meter.

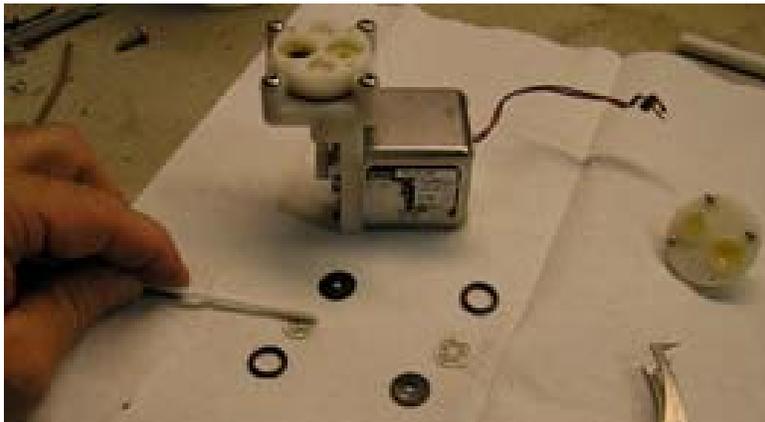


To change the flow rate the hex wrench is used to change the stroke. Movement of the cam is changed by loosening one screw and then tightening the opposite screw. Checking the flow rate and then adjusting the cam until the desired flow rate is achieved.



If pump does not operate at required flow rate, disassembly and cleaning of pump head will have to be performed.

Take off head with four screws and remove the valves. Care must be taken not to tare the Teflon valve. Clean with methanol using a Q-tip and reassemble. Be sure and replace the O-ring, valve and washer in the same order that as removed.



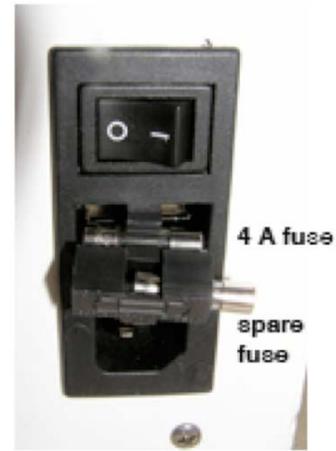
If the valves become torn or the rubber washer is distorted the valve assembly can be replaced. Instructions are in the replacement kit.

SUPPLIES:

Puff Pump can be purchased from Teague Enterprises with the plug attached and calibrated.

Checking and replacement of fuse.

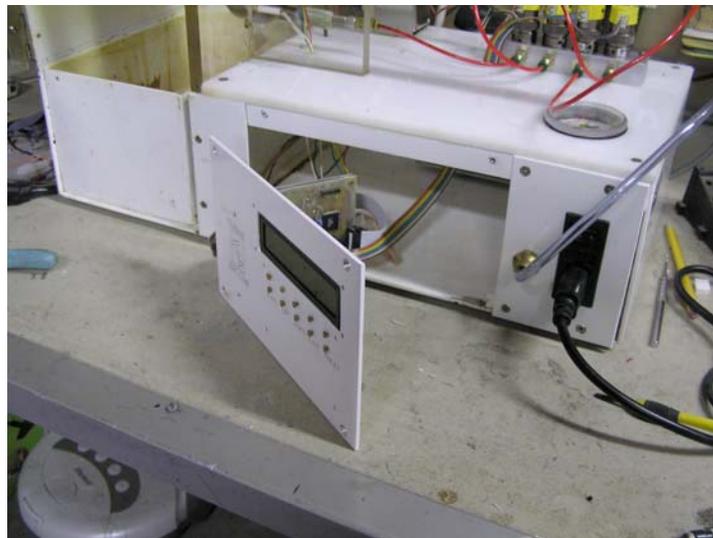
1. Remove the power cord from the receptacle.
2. Using a small screwdriver pry the fuse drawer out.
3. The fuse may be checked by a resistance meter.
4. If none is available just replace the fuse with the spare one in the front part of the fuse drawer.



Removal and replacement of the electronics drawer

1. Remove the drawer.

Remove the 4 screws from the drawer and pull it out from the machine.



2. Remove wires from the electronics. –The wires should be removed by holding the plugs and rocking them back and forth while pulling off, do not pull on the wires themselves. When replacing be careful of the solenoid plug to make sure it is aligned with the pins before pushing the plug on.

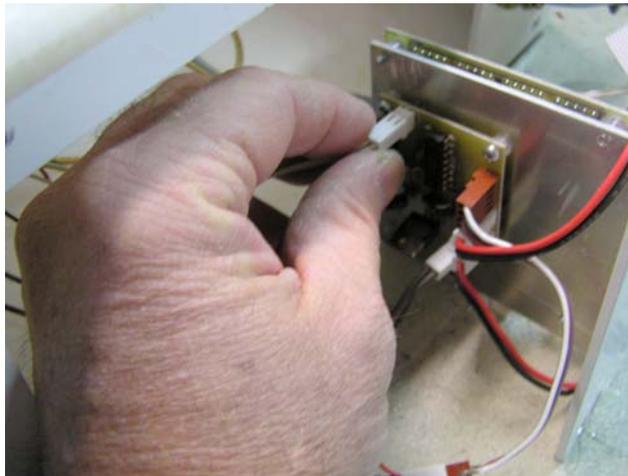
- a. Power



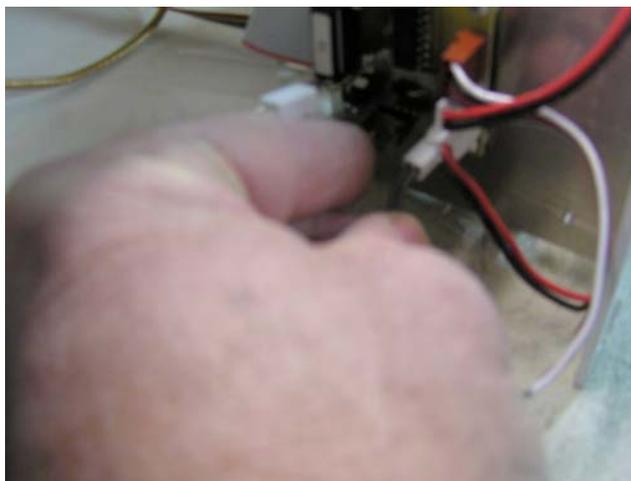
b. Solenoid plug



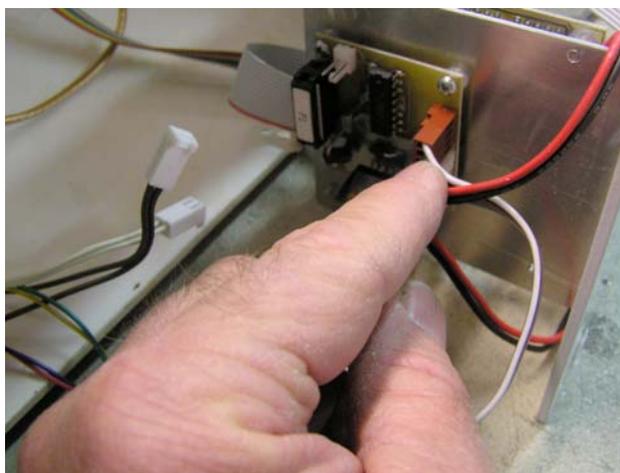
Zero position (connected pair) do not plug lighter wire here!



Lighter wire (two brown wires) When reassembling be careful not to reverse with zero wire.



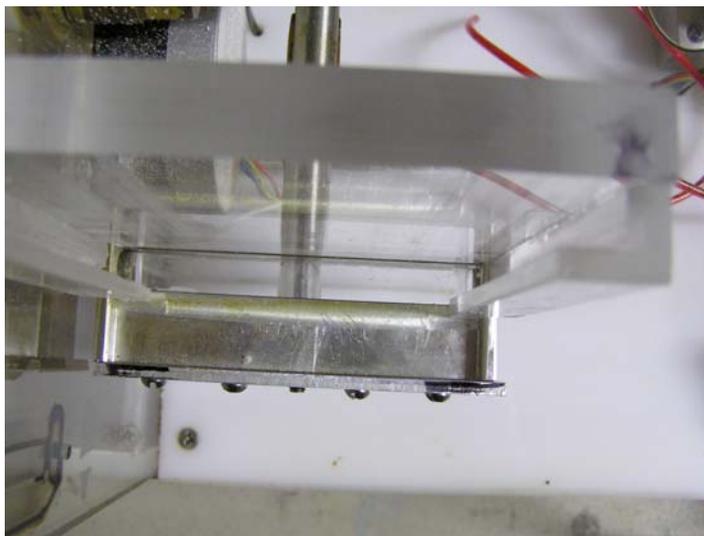
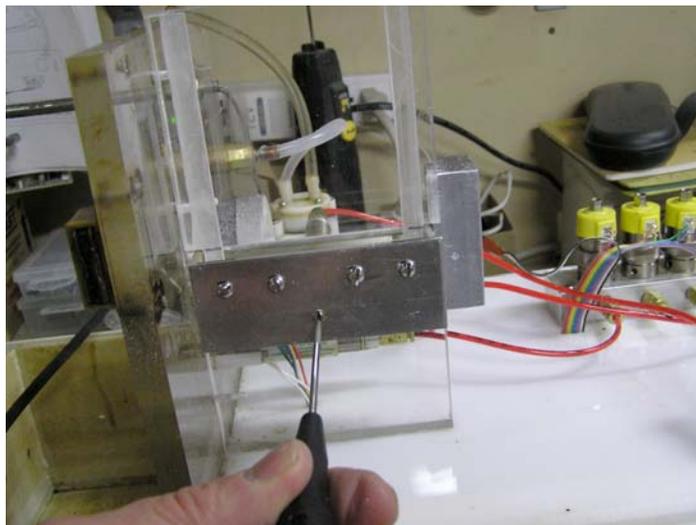
Stepper motor – this has four wires



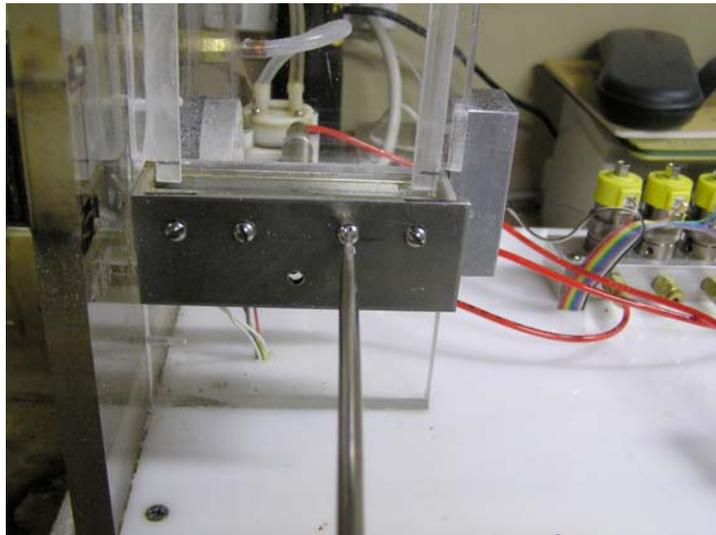
Alignment of the ML loader:

The slide piece that moves the cigarettes into the chamber where they can be pushed into the wheel must be aligned properly for the mechanism to work properly.

To remove the slider use a compressed air source at 30 psi or less applied directly to the air cylinder that moves the ml slider. An adaptor that goes from ¼ to 1/8 tubing can be used to connect to the compressor. If using the air compressor in the hood unit turn off the air pressure by turning the air regulator off (ccw) and remove the ¼ “ line from the smoking machine. Take the line from the ml cylinder solenoid and connect it to the line from the compressor using the adaptor (WWG# 6LG69) and apply pressure to the cylinder. The slider will come out all the way. Now the screw on the plate can be adjusted so the back exactly lines up with the ml slider:



If the plate is binding the four screws are loosened when the slider is retracted. Then the screws on the plate are retightened when the slider is in the center.



The slider plate can be tested by turning pressure on and off of the ml cylinder till the slider moves freely.

Supplies:

| | | | |
|---|-----------|---|---------------|
| Orlando Chambers, Ph.D. College of Agriculture Reference Cigarette Program ochamb@uky.edu Phone: (859) 257-7044 Fax: (859) 323-1077 W. W. Grainger Inc. | M | 3R4F reference cigarettes Shipping charge | 1000=M |
| | rl | Activated carbon filter | 5W095 |
| | rl | lightweight food hose 1" | 3JT83 |
| | rl | polyurethane tubing 1/4x.156 | 4HL92 |
| Fisher Scientific 800-766-7000 | rl-50 | 1/8x1/4 silicone tubing | 14-176-332B |
| | rl-25 | 3/8 x 1/4 silicone (puff line) | 14-169-1F |
| VWR.com | 100 Pk | 25 mm EMFAB TX40H120-WW | 28150-925 |

Teague Enterprises
2829 Cascade Pl
Davis, CA 95618
530-406-8893
Teague-ent.com

10 pk Nichrome lighters
10 pk Wheel gaskets for holding cigarettes
ea 12 VDC adjustabe stroke pump
ea Valve repair Kit

Ltr-pk
Wh-gsk
TD-3LSA
TD-02

Wiring for TE -10c with pressure shut off mod

